

5/43

(4)

| | | |
|---------------------------|---------------------|----------------|
| DART AEROSPACE LTD | Work Order: | 24587 |
| Description: Stem | Part Number: | D3407-3 |
| Dwg: D3407 Rev. C | Qty: | 6 |
| | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 1 | DC | Issue Traveler | HA | 05.10.18 | 6 |
| 2 | MC | Turn as per Folio FA597 Rev: <u>A</u> & Dwg D3407 Rev: <u>C</u> Material: 17-4ph SS Round Bar Ø0.750 (M17-4-R0.750) Identify for D3407-3 Batch: <u>M18742</u> | me | 05/10/21 | 6 |
| 3 | QC2 | Inspect parts as they come off the machine | me | 05/10/21 | 6 |
| 4 | QC8 | Second check | SD | 05.10.24 | 6 |
| 5 | MC | Deburr, no sharp edges | me | 05/10/21 | 6 |
| 6 | MV | Machine as per Folio FA597 and Dwg D3407 | SD | 05.10.24 | 6 |
| 7 | QC2 | Inspect parts as they come off the machine Identify as D3407-3 | SD | 05.10.24 | 6 |
| 8 | QC8 | Second check | 36 | 05.10.24 | 6 |
| 9 | MV | Deburr | SD | 05.10.24 | 6 |
| 10 | ST | Identify and Stock | APL | 05-10-24 | 6 |
| 11 | AC | Cost / part: <u>22.16</u> | sur | 05-10-25 | 6 |
| 12 | DC | Close W/O <u>22.16</u> Inspect Level 21 | HA | 05/10/25 | 6 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.10.18 | New issue | KJ/EC | EC |

RELEASED
05.10.18

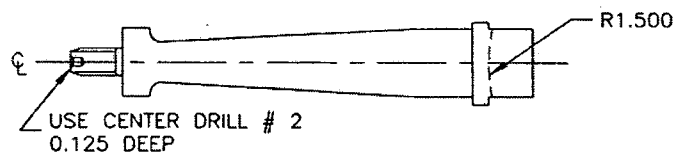
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 05/18/25

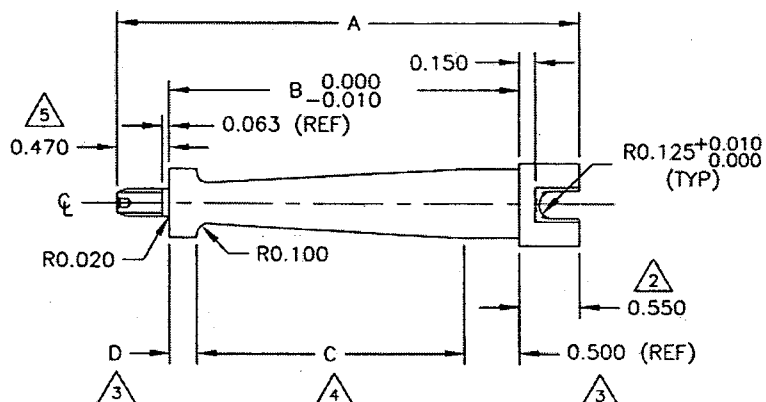
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED

05.09.12



| PART NUMBER | A | B | C | D |
|-------------|-------|-------|-------|-------|
| D3407-1 | 5.270 | 4.250 | 3.250 | 0.500 |
| D3407-3 | 4.325 | 3.305 | 2.555 | 0.250 |

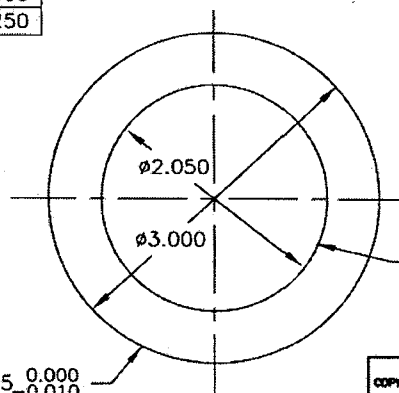
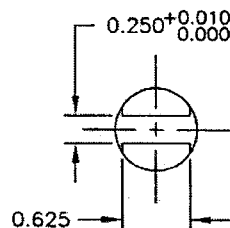
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

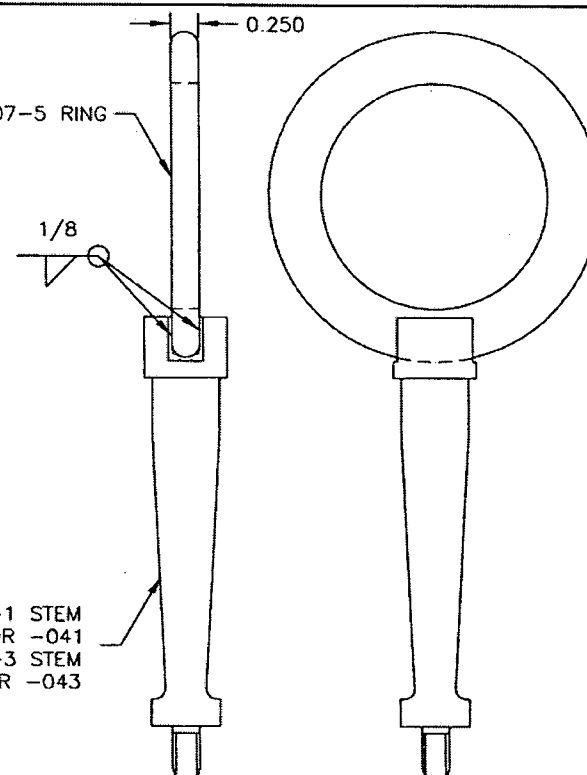
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043



D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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| | | |
|-------------|----------|-------------------------------------|
| C | 05.09.09 | -1/-3 LONGER FOR FIT W/ WASHER |
| B | 05.06.17 | UPDATE DIAMETER, THREAD CLASS ADDED |
| A | 05.03.16 | NEW ISSUE |
| DESIGN | CP | DRAWN BY CP |
| CHECKED | ✓ | APPROVED |
| DATE | 05.09.09 | TOW RING |
| DRAWING NO. | D3407 | REV. 0 |
| TITLE | TOW RING | SHEET 1 OF 1 |
| SCALE | 1:1 | |

WORK ORDER
0.24587
RETURN TO
ENGINEERING
WITHOUT NOTICE
CONTROLLED COPY
SHIP COPY

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
09:31 am

Work Order No : 0024587
Project Name : D3407-3
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3407-3
Description : Stem
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 10-18-05
Est Finish Date : 10-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |

